

Date: Thursday, 02/04/2009 2:25:50 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 46849	
Estimate Number : 11534	
P.O. Number :	Part Number : D30401
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D3040 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 42944	Material :
Written By :	Due Date : 20/04/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.04.02</u>	
Comment : Est:B 01.11.08 Revised Step 2 and Added Inspection Level 21 S M Est Rev:C Now on WaterJet 07-03-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0187X04000	6061-T6 Bar .178 x 4.00
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Comment: Qty.: 0.3718 f(s)/Unit Total: 3.7181 f(s)
 6061-T6 Bar .178" x 4.0"
 Material: 6061-T6 alum plate 0.188" thick B 9-4-6 Batch: 106 652

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3041
 Dwg Rev: B
 Prog Rev: B

B 9-4-6

2-Deburr if necessary

B 9-4-6 M-1 09/04/07(12)(12x)(P10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEB 9-4-6

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK09.04.07(12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock
 Location: WA18

09.04.07 12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3040-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/07

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46849</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/07	2.0	Drill holes open holes are slightly under size from w. J, which is a good thing. 2.c: Jet offset.		drill open holes to 0.257 as per dwg. clear all edges - holes	M. H. 09/04/07			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 46849

Part Number: D30401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

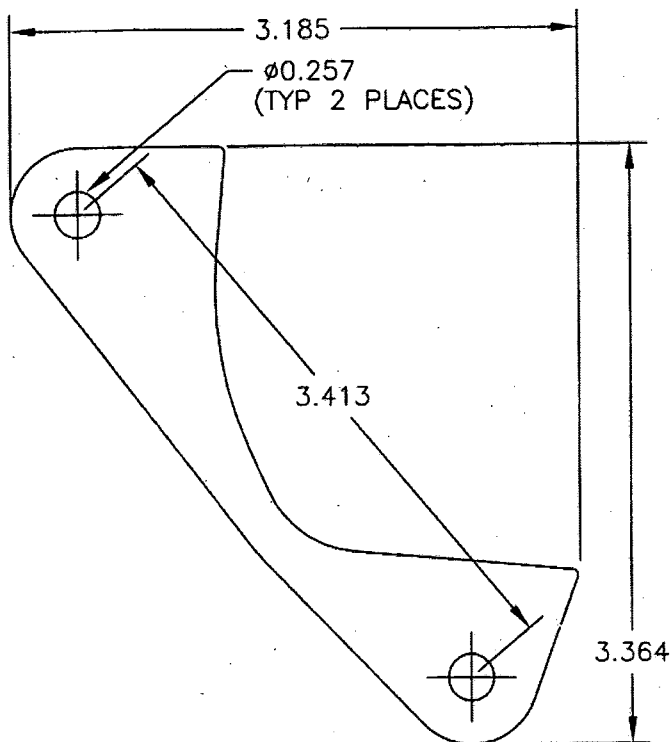
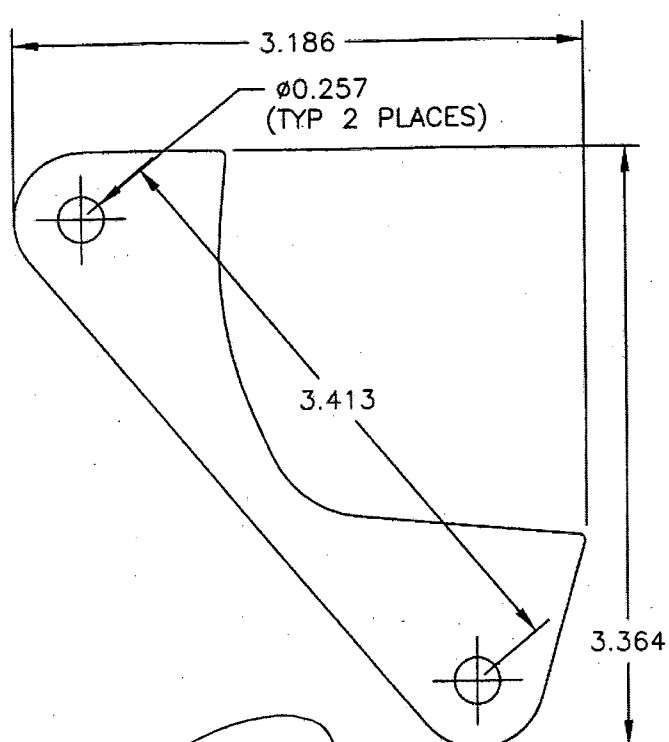
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
01.09.07

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3040	REV. B SHEET 1 OF 1
DATE 01.09.04		TITLE MOUNTING LUG	SCALE 1:1
A	01.06.27	NEW ISSUE	
B	01.09.04	CHANGED PROFILE 5 DEGREES	

**NOTES**

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
(REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

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